








Work Order ID 64361

Thursday, December 02, 2010 1:31:56 PM


Page 1

Item ID: D3570-3 Accept  Setup Start 
Revision ID:
Item Name: Bracket Stop 
Start Date: 12/2/2010 Start Qty: 15.00  Cust Item ID:
Required Date: 12/15/2010 Req'd Qty: 15.00  Customer:
Reference:

Approvals: Process Plan: RL Date: 10-12-2 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							

FLOW CNC Waterjet
6061 . 125
1-Cut as per Dwg D3570
Dwg Rev: E
Prog Rev: E
GRAIN DIRECTION AS PER DWG
2-Debur if necessary

B10-12-6

(17)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

B10-12-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64361

Thursday, December 02, 2010 1:31:56 PM



Page 2

Item ID: D3570-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/2/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 15.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3570 Using DT8945

2-Cut excess materials per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

=) m-k 12/12/07

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.00/12/07

17

17X

17

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 64361



Page 3

Thursday, December 02, 2010 1:31:56 PM

Item ID: D3570-3

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/2/2010 Start Qty: 15.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 15.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				17.		PR-10-12-7	
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 112588 Memo START TIME: 8:00 OVEN TEMPERATURE: 300° FINISH TIME: 8:30	0.00 0.00				17.		PR-10-12-9	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		lll 10/12/09		17			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Abstract

Page 4

Accept

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Setup Start

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

Identify as per dwg & Stock Location: GA

0.00

[REDACTED]

Packaging

Memo

0.00

Packaging

Sd/- (0/12/10)

17

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/14 *[Signature]*

2/10/20
(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, December 02, 2010 1:32:00 PM

Page 1

Work Order ID: 64361



Parent Item: D3570-3



Parent Item Name: Bracket

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 15.00

Required Qty: 15.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	72.0600	0.087	1.373684			



6061-T6 .125 Sheet



PR 10-12-6

Location

Loc Qty

Loc Code

MAT21

72.06

113608

72.06

113608

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64361
Description: Bracket		Part Number:	D3570-3
Inspection Dwg: D3570	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.211	X		VIB02	
0.435	+/-0.010	.433	X		V	
0.65	+/-0.010	.655	X		V	
1.841	+/-0.010	1.845	X		V	
2.064	+/-0.010	2.067	X		V	
2.38	+/-0.030	2.376	X		V	
0.359	+/-0.010	.363	X		V	
0.557	+/-0.010	.560	X		V	
1.943	+/-0.010	1.941	X		V	
2.141	+/-0.010	2.139	X		V	
5.25	+/-0.030	5.251	X		V	
1.00	+/-0.030	1.005	X		V	
0.125	+/-0.010	.128	X		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-12-6	Date:	10/12/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.09	New Issue	KJ	M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

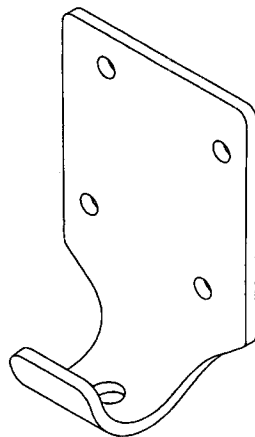
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

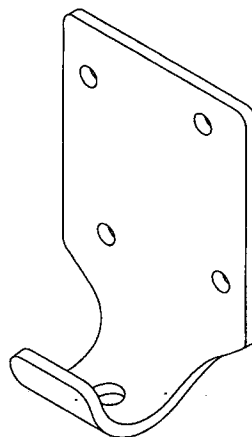
NOTE: Date & initial all entries

SHOP COPY
RETURN TO 4
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64361

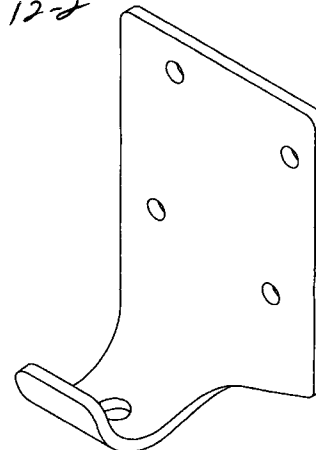
BS10 12-2



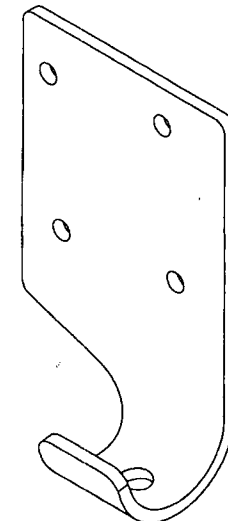
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

RELEASED
09/04/22

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.04.22	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

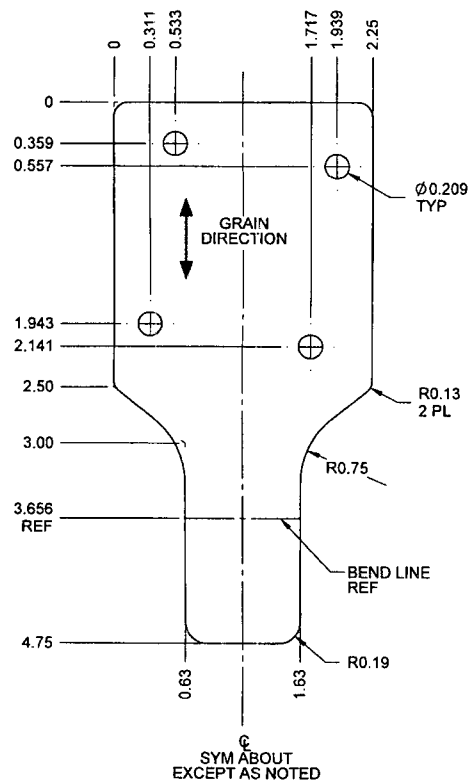
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

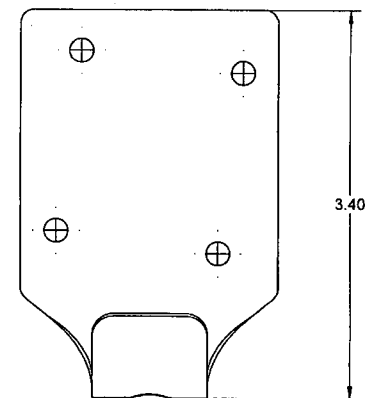
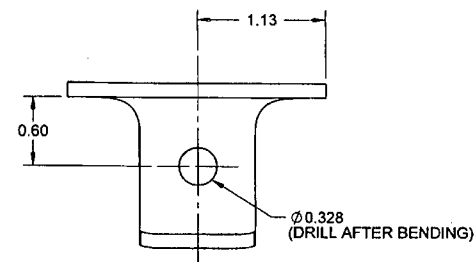
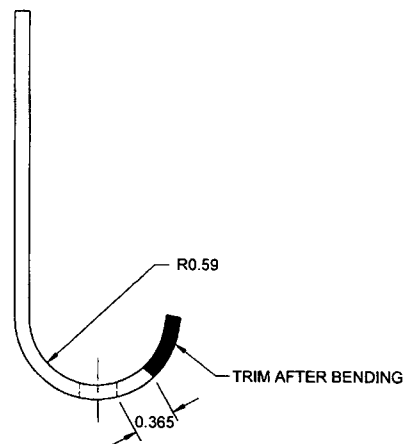
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FROM D3570-1F)

RELEASED
29/10/13

w/o 44341

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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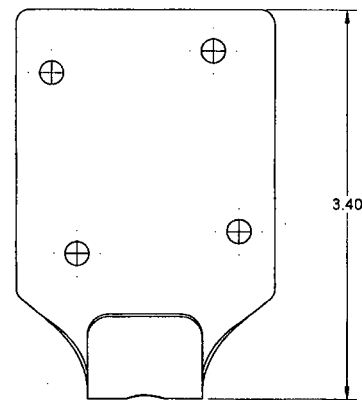
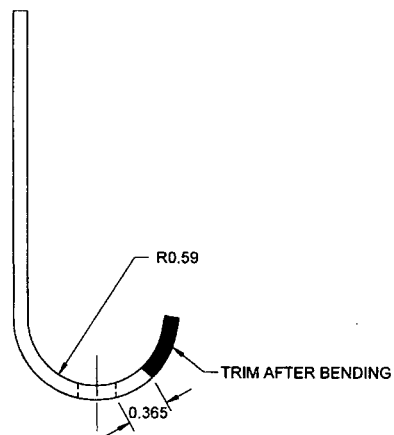
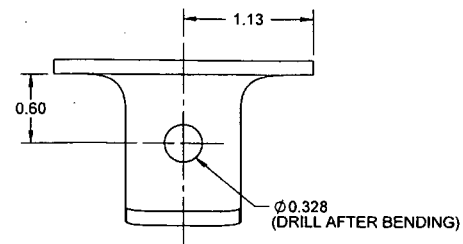
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NOTE: Date & initial all entries



D3570-2 BRACKET
(MAKE FROM D3570-1F)

wb 443a1

RELEASED
09/04/22

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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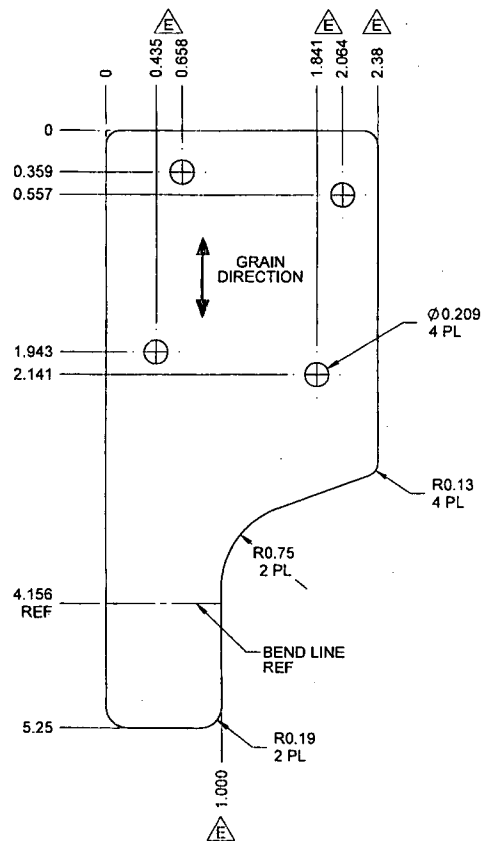
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

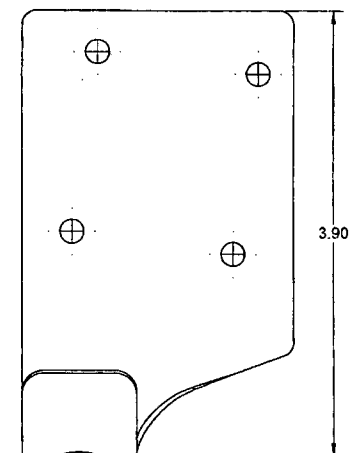
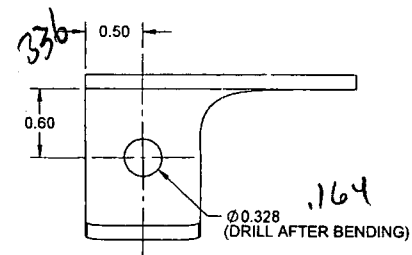
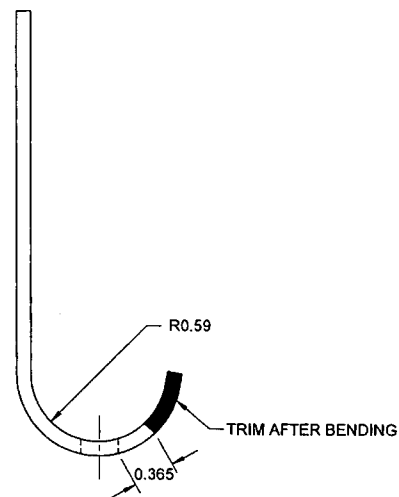
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

RELEASED
2/12/13 MB

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 4 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.	SH	BRACKET	NTS
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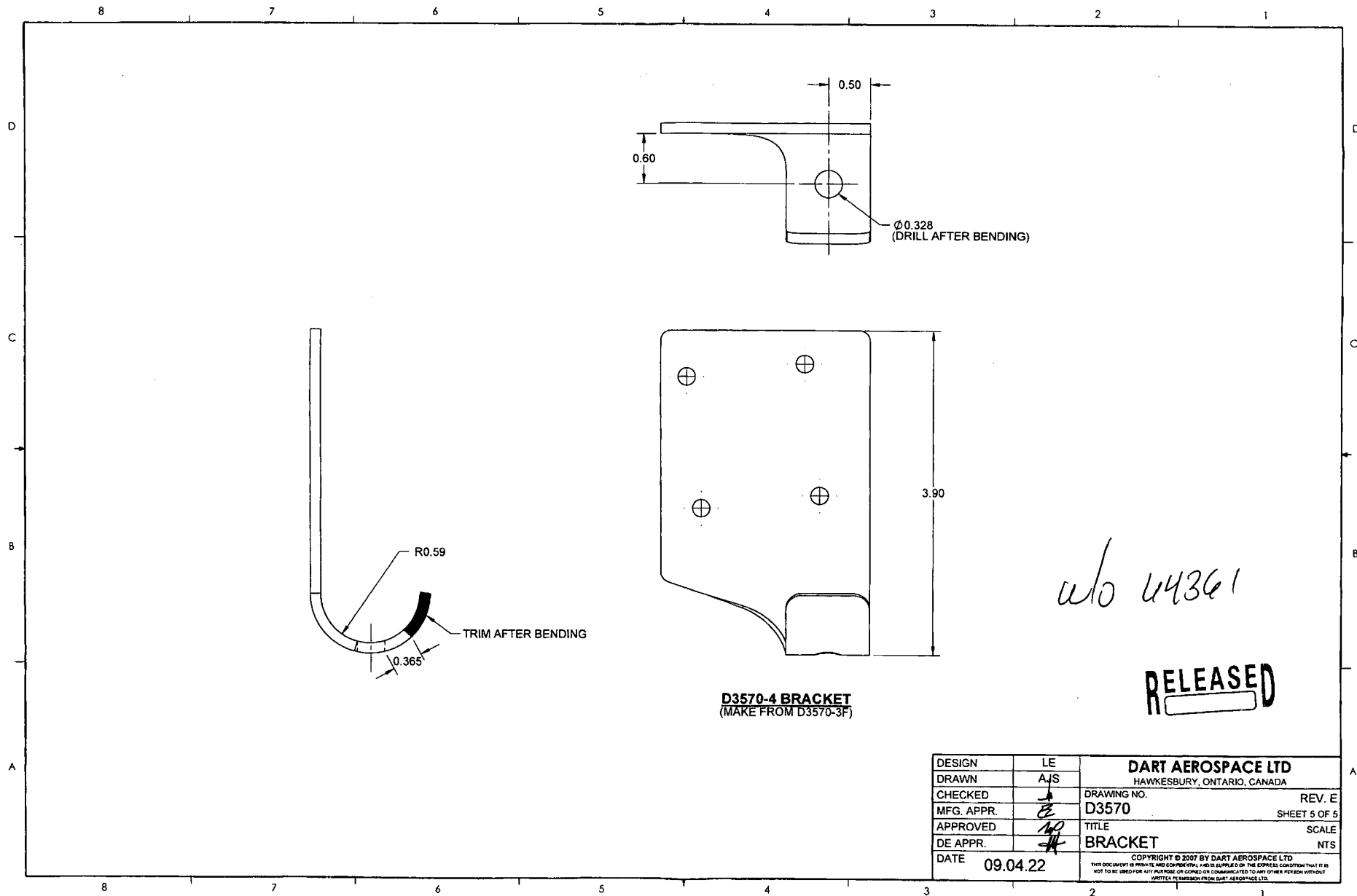
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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